

Work Order ID 64887

December 21, 2010 1:10:09 PM



Page 1

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-12-21 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3195	Rev A

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

JL 11/01/17

(4)

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-
3□2-Deburr

JL 11/01/18

(2)

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

JL 11/01/18

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

12/11/01/18

4 0



QC

Memo

0.00

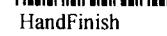
140

Chemical Conversion Coat per QSI005 4.1

0.00

11/01/18

4 0



HandFinish

Memo

0.00

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:35

OVEN TEMPERATURE:

FINISH TIME:

9:05

H. B 11-01-18

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Item ID: D3195-043

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Stop



Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

⇒ 11/10/10

4

0

QC

Quality Control

170



Small Fab

0.00

Small Fab

Small Fab

Memo 0.00

Small Fab

1-Lightly Sand bonding surface□2-Bond D3195-7 into D3195-13as per Dwg
D3195□A/RContact Cement 11/10/95

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Work Order ID 64887

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Stop



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Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

190

Identify as per dwg & Stock Location: 2460ASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Memo

0.00

11/19/04x

Packaging

200



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/19MF

11-01-19

Picklist Print

December 21, 2010 1:10:08 PM

Page 1

Work Order ID: 64887



Parent Item: D3195-043



Parent Item Name: Bracket Assembly

Start Date: 12/21/10

Required Date: 12/30/10

Comments: IPP Rev:A New Issue 05-11-08 JLM

Start Oty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7		Manufactured	No		100	Each	8.0000		1	4			

$D = 1$

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	8	
64534	9	

M6061T6B1.500X01.25
0

Purchased No.

6061-T6 Bar 1.50 x 1.25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT10	28.25595	
107461	1.73315	
110936	26.5228	

DART AEROSPACE LTD	Work Order:	64887
Description: Bracket	Part Number:	D3195-3
Inspection Dwg: D3195	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

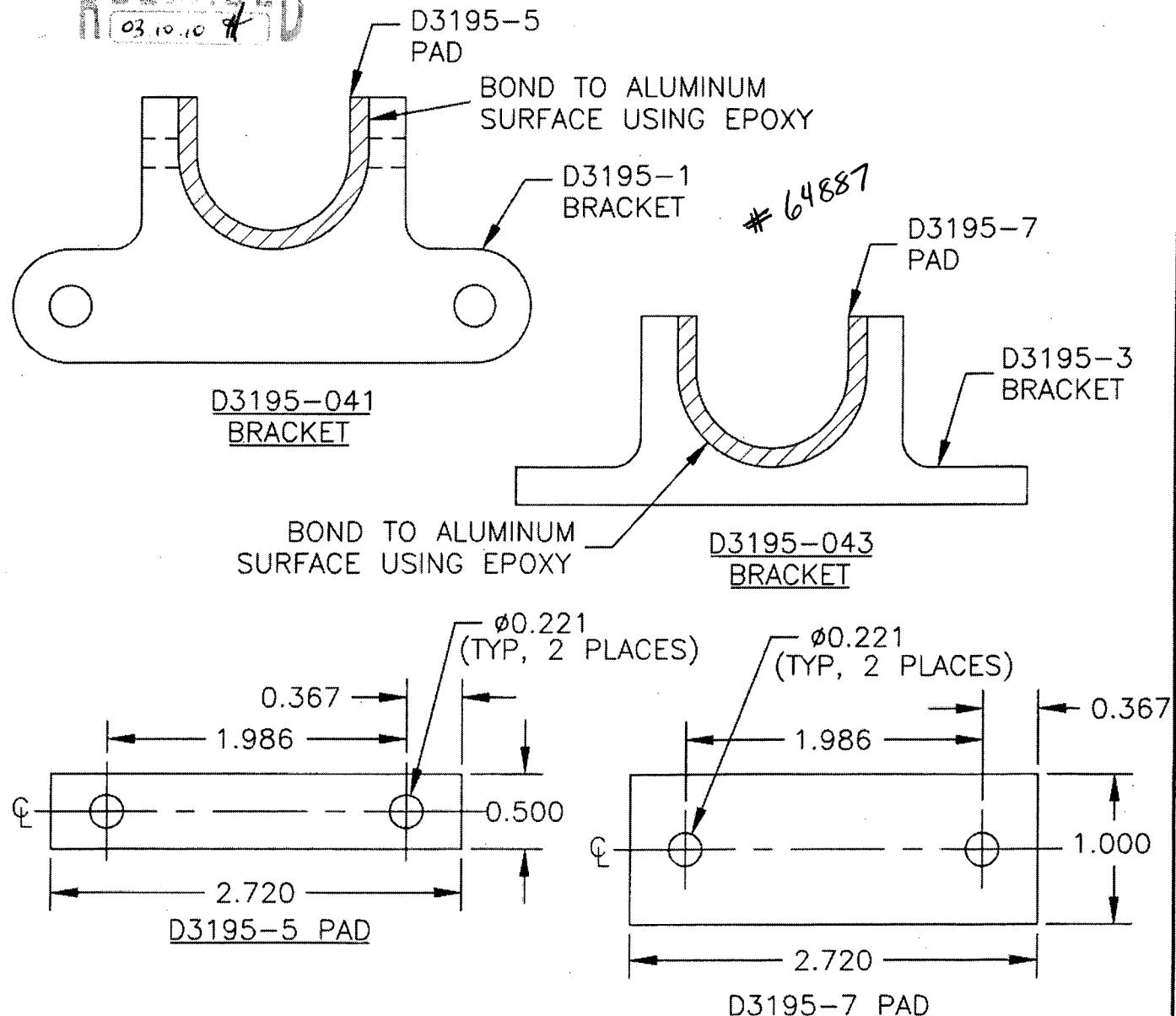
Measured by:	<u>SL</u>	Audited by:	<u>SL</u>	Prototype Approval:	N/A
Date:	11/01/18	Date:	11/01/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	<i>[Signature]</i>
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	<i>[Signature]</i>

DART

COPY IS OK

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3195 REV. A
DATE		SHEET 1 OF 3
03.06.23		TITLE
		SCALE 1:1
A	03.06.23	NEW ISSUE

RELEASED
03.10.10D3195-5 & D3195-7 PAD

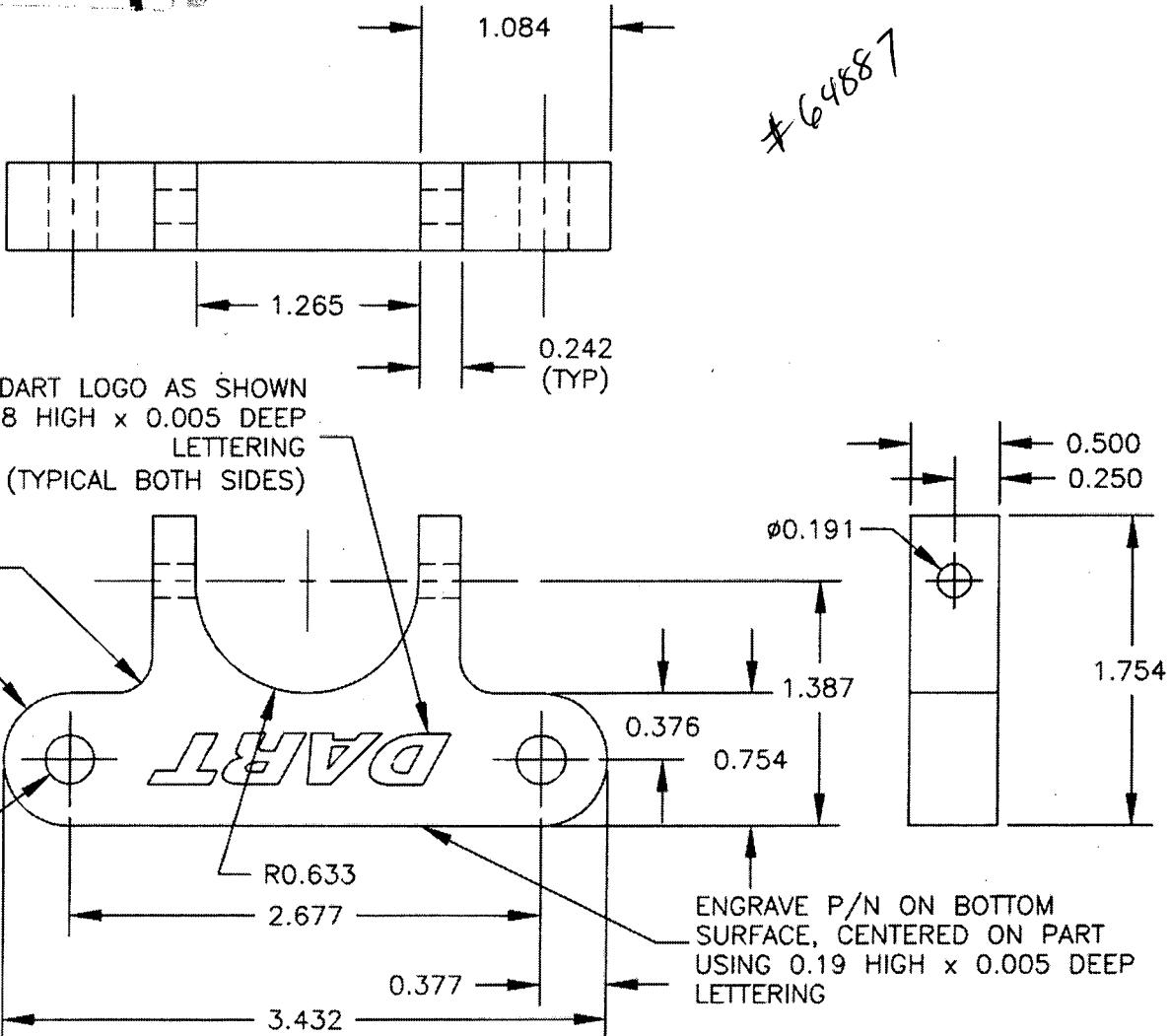
- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES



DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3195	REV. A	SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1	

RELEASED
03.10.10 #

THE BOSTONIAN



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	DRAWN BY	CP
CHECKED	APPROVED	CP
DATE		DRAWING NO.
03.06.23		D3195

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A

SHEET 3 OF 3

SCALE

1:1

